

Work Order ID 64257

Wednesday, December 01, 2010 8:32:08 AM



Page 1

Item ID: D3953-7

Accept



Setup Start



Revision ID:

Stop



Item Name: Spring Spacer

Start Date: 12/1/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 12/3/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: mfDate: 10-12-01

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3953	C								

100

0.00



Hardinge

Memo

0.00

Hardinge CNC Lathe Small

TURN AS PER FOLIO FA854 & DWG

FOLIO REV: CDWG REV: C

DEBURR

SA 10/12/0110 Ø

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

SA 10/12/0110 Ø

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D3953-7

Accept

Revision ID:

Item Name: Spring Spacer

Start Date: 12/1/2010 Start Qty: 10.00

Required Date: 12/3/2010 Req'd Qty: 10.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

H.A 10/12/01

10

0

130

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

10/12/15L 100

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/12/01 10
B10-12-1
(10)

W/O:		WORK ORDER CHANGES					
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Picklist Print

Wednesday, December 01, 2010 8:32:07 AM

Page 1

Work Order ID: 64257



Parent Item: D3953-7



Parent Item Name: Spring Spacer

Start Date: 12/1/2010

Required Date: 12/3/2010

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP RevA: New issue DD verified by:EC
revC DD 10.03.02 verified by:EC

IPP Rev:B as per dwg

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELNR0.750 		Purchased				100	f	106.5370	0.05	0.526316			
Delrin Round Bar 0.75"													



SA 12/12/10

Location

Loc Qty

Loc Code

MAT

50

116183

50

MAT050

56.537

112418

0.12

115472

56.417

45 PL

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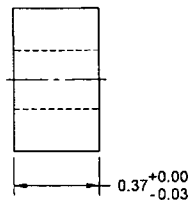
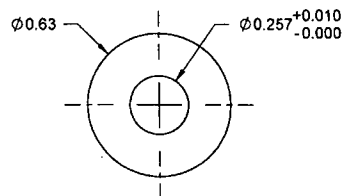
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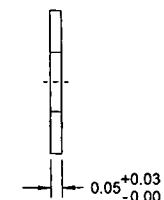
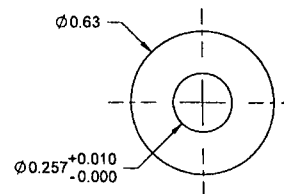
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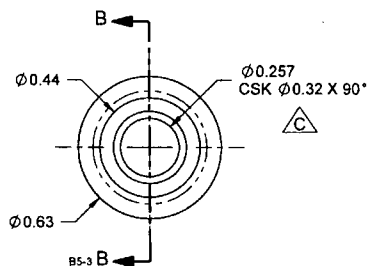


D3953-7 GAS SPRING SPACER

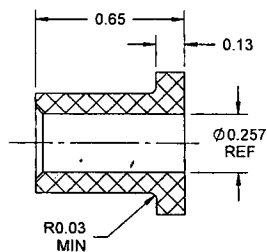


D3953-9 GAS SPRING WASHER

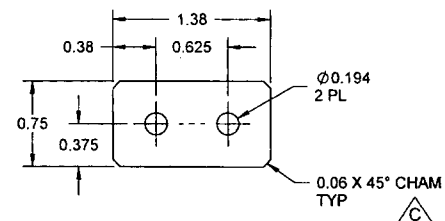
#64257



D3953-11 GAS SPRING SPACER



SECTION B-B 87-3



D3953-13 GAS SPRING SPACER

NOTES:

1) MATERIAL -7, -9 & -11: DELRIN II 150E OR ACETRON GP ACETAL, BLACK
REF DART SPEC M-DELRIN-R

-13: AISI 304 STAINLESS STEEL BAR
REF DART SPEC M304B

- 2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION -13 ONLY: IDENTIFY WITH DART P/N "D3953-13" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT -7/-9/-11: < 0.01 lbs EACH
-13: 0.17 lbs

RELEASED
2010-02-26

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3953	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	GAS SPRING LID COMPONENTS	NTS
DATE	10.01.29	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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